

Work Order ID 68482

Thursday, April 14, 2011 10:02:10 AM



Page 1

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 4/14/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Handwritten signature

Date: 4-14-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3296

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Debur if necessary

B11-5-3

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-3

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Handwritten signature

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68482

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Page 2

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Panel

Start Date: 4/14/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
	N/A								
140		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

12 / 11/05/04

= 7 m-h 11/05/04 (12x)

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Panel

Start Date: 4/14/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 106

0.00



Packaging

Memo

0.00

Packaging

11/5/5 sf 12

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/6 JF

CMF
11-05-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:02:16 AM

Page 1

Work Order ID: 68482



Parent Item: D3296-3



Parent Item Name: Door Panel



Start Date: 4/14/2011

Required Date: 4/21/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:E Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased	No			110	sf	330.5700	0.6532	8.250947			
													

B11-5-3

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

330.57

113867

1.19

117018

41.38

117392

288

117392

12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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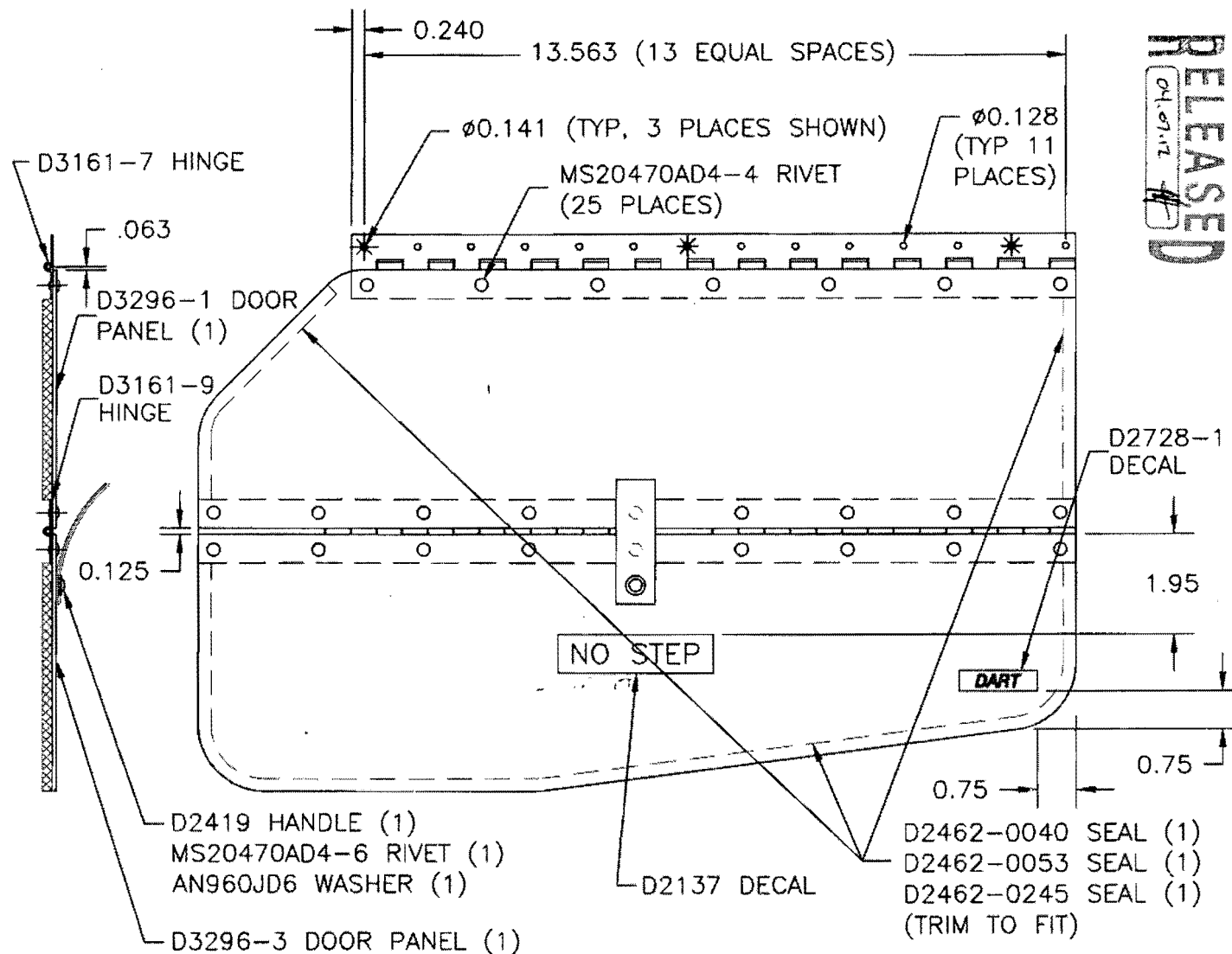
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

S
REMARKS
ENCLOSURE
UNCONTROLLED DOCUMENT
SUBJECT: D3296-1
WITH: D3296-1
WORK ORDER
NO. 18482
11-01-14

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HANKEBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
04.06.28	D3296	1 OF 2
	TITLE	SCALE
A	DOOR ASSEMBLY	1:3
	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

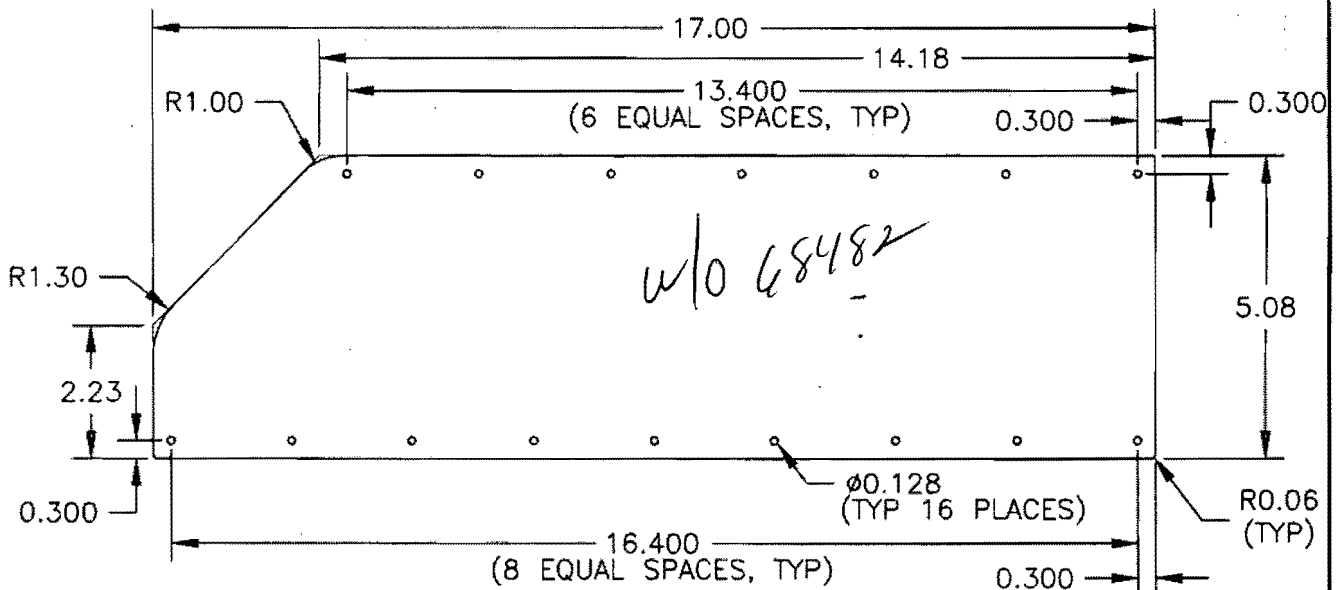
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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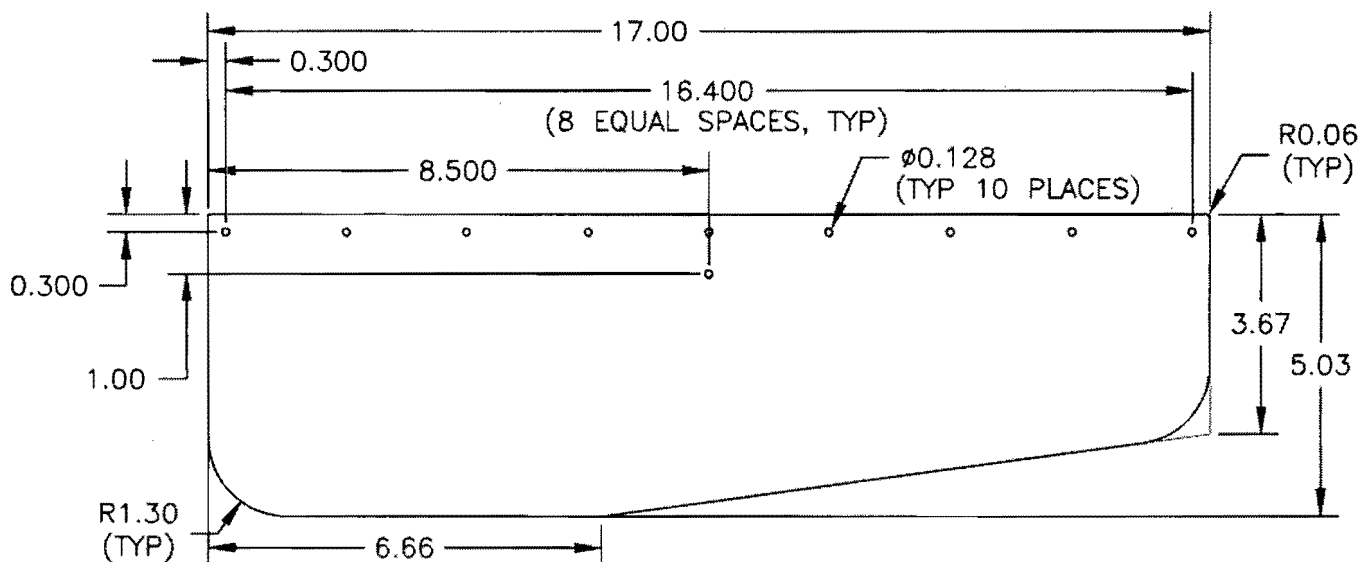
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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